



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18604-1
Job Sheet 201772



DAS
21
9-33

Part No: RBT18604-1

Job Qty: 5 pcs

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18604 Rev.5 IPP Rev. A 18.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-2500Y - 1	5 pcs	11/29/19	11/29/19	1.00	1.25	SL-2500Y - 1	11/19-10-24
120	QC 2	5 pcs	11/29/19	11/29/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	11
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

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130 QC 8	5 pcs	11/29/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
150 Outsource - 4 - Anodize	5 pcs	11/29/19		GRO002-VC	8
160 Packaging 2-1 - Receive - B4B	5 pcs	11/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	

19/10/30

2019-10-31

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DAS
23
9-89

170 QC 6	5 pcs	11/29/19	0.00 0.00	Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	DAS
				QC 6 - 68	NOV 07 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	5 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS
				Packaging 3 - 5 - B4B	28
				Packaging 3 - 6 - B4B	9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
190 QC 21 - SA	5 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	NOV 11 2019

Part Op 110 - MORI SL2500Y LATHE - 1-Machine as per DWG, FC460 FOLIO REV: 4.4 DWG REV: 5
 Descriptions: 2-Deburr
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 150 - Issue P/O to GROUPE ALTECH; PO 441953 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2
 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required
 160 - Receive & Inspect for Damage & Mat'l Certs

10/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

170 - QC6- All purchased or subcontracted products
180 - Identify as per dwg & Stock Location:
190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.000	6061-T6 Round Bar 3.000"	.4150 ft (.083 ea)	110-SL-2500Y - 1	S283780

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-2500Y - 1	M6061T6R3.000	0	0	0

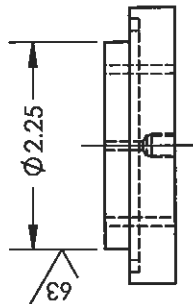
Part Specifications

Specifications could not be found.

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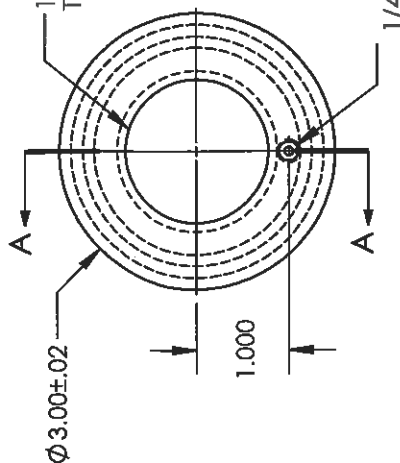
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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DISTANCE FROM FACE TO STEP INCREASED TO .30 TO ENSURE ADEQUATE THREAD ENGAGEMENT.	3/9/2001		
2		O-RING GROOVE ENLARGED TO BETTER FIT O-RING.	3/23/2001	DW	
3		DISTANCE FROM FACE TO STEP REDUCED TO .265.	4/4/2001		
4		GREASE FITTING CHD TO 45° FOR EASE OF USE, MUST FACE OUT.	2/10/2003		
5	16-0202	1. CHD DIM WAS Ø3.00 ±.02, WAS Ø.09 THRU ALL 1.563-18 UNF-3B THRU ALL. 2. CHD DIM WAS Ø3.00 ±.02, WAS Ø.09 THRU ALL 1.563-18 UNF-3B THRU ALL. 3. WAS BORE Ø1.563-18 UNF-3B THRU ALL.	10/24/2016	RJC	JAG



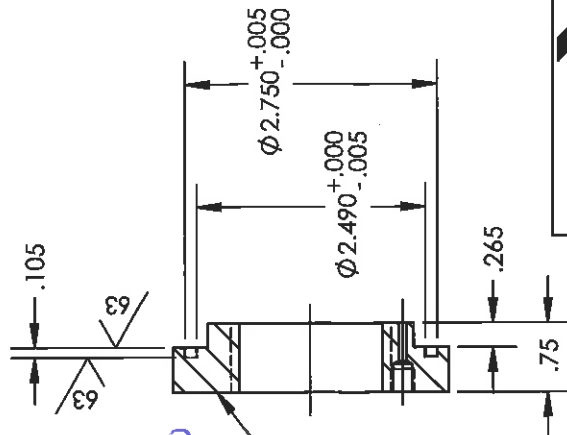
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 201772 MJS

1.563-18 UNF-3B THRU ALL



ENGRAVE T/N, S/N, "MADE IN USA"

1970-10



SECTION A-A



TITLE REGREASE TOOL - SWASH PLATE

DWG NO.	RBT18604-1	REV	5
MAT'L	6061	UNLESS OTHERWISE SPECIFIED	
FINISH	RED ANODIZE	DIMENSIONS ARE IN INCHES	
SPEC	MIL-A-8625F, TYPE II, CLASS II	FRACTIONS ± 1/8	
DRAWN BY:	CLOUGH	XXX ± .005	
CHECKED:	DUERFELDT	XX ± .01	
OPPS APPR:	ANDERSON	X ± .1	
QA APPR:	LINDSAY	ANGLES ±.5°	
APPROVED:	GILBERT	SURFACES ±.125	
SCALE	1:2	1. BREAK ALL SHARP EDGES	
DATE	10/24/2016	.015 x 45° OR .015R	
		2. DIMENSIONAL LIMITS APPLY	
		AFTER PLATING	
		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
		USED ON MODEL	
		MD 369 D,E, & F	
		SHEET 2 OF 3	

(-1)

BODY



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐													
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)													
Description Work Order Deviation		Disposition															
Root Cause		FAULT CATEGORY															
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044955



Supplier: GRO002-VC
Group Alted
2455 Halper
St Laurent
QC
H4S 1N9 Canada
Phone: 514-35-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury,
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044955

PO Date: 10/31/19

Due Date: 11/11/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-01

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198984	RBW8500G01751-3G	RBW8500G01751-3G Rev A	Puller -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type 6061T6 -Certificate of Conformity is required	Firmed	-	11/11/19	7 pcs	0 pcs	7 pcs	\$6.94/pcs	\$48.58
2	201253	RBT18902-A	RBT18902 Rev C	Plate A -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type 6061T6 -Certificate of Conformity is required	Firmed	-	11/11/19	6 pcs	0 pcs	6 pcs	\$5.18/pcs	\$31.08
3	202213	C2-1-1	C2-1-1 Rev 4	Manual Release Knob (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	11/11/19	20 pcs	0 pcs	20 pcs	\$1.32/pcs	\$26.40

11/1/2019

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044955



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	201772	RBT18604-1	RBT18604 Rev 5	Body -Issue P/O to GROUPE ALTECH -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	11/11/19	6 pcs	0 pcs	6 pcs	\$4.67/pcs	\$28.02
5	200698	RBD29905-7	RBD29905 Rev G	Bushing -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type 6061T6 -Certificate of Conformity is required	Firmed	-	11/11/19	14 pcs	0 pcs	14 pcs	\$0.89/pcs	\$12.46
6	201336	RB H4713-1	RB H4713 Rev F	Drain Hose Body -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2	Firmed	-	11/11/19	10 pcs	0 pcs	10 pcs	\$3.77/pcs	\$37.70
Grand Total:												\$184.24

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/1/19 9:14 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(023731-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

023731 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
06-Nov-2019		Jigar Patel				POHB044955			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		À venir/ Back Order
2	RBT18902-A Rev.C 201253	RBT18902 ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE-2 CLASS-2 WATER SEALANT MATERIAL TYPE 6061T6		ANODIZE CH	6	6	0	0	0
3	C2-1-1 Rev.4 202213	C2-1-1 ANO-RED [ANODIZE RED] AS PER IAW MIL-A-8625 TYPE 2, CLASS 2 WATER SEALANT		ANODIZE CH	20	20	0	0	0
4	RBT18604-1 Rev.5 201772	RBT18604 01-ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE-2 CLASS-2 WATER SEALANT MATERIAL TYPE 6061T6		ANODIZE CH	6	6	0	0	0
5	RBD29905-7 Rev.G 200698	RBD29905 01-ANO-RED [ANODIZE RED] AS PER MIL-A-8625, TYPE 2, CLASS 2 WATER SEALANT MATERIAL TYPE 6061T6		ANODIZE CH	14	14	0	0	0
6	RB H4713-1 Rev.F 201336	RB H4713 ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE-2 CLASS-2 WATER SEALANT		ANODIZE CH	10	10	0	0	0

RECEIVED

NOV 07 2019

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.